

# Work Order ID 71323

Tuesday, June 28, 2011 10:05:47 AM

Page 1

Item ID: D412-742-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Float Skidtube

Start Date: 6/28/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 11-06-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

If D412-742-043 is a W/O on it's own,  
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

N/A - 013 4 11-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Start Date: 6/28/2011 Start Qty: 1.00



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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.  
A/R ☐ Sikaflex-241/-291 1117516  
Expiry date: 15/01

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 1117516  
Expiry date: 15/01

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.  
A/R ☐ LPS Procyon 1114109

1 0 11 6/27/07

W/O:		WORK ORDER CHANGES					
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Start Date: 6/28/2011 Start Qty: 1.00



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Required Date: 7/28/2011 Req'd Qty: 1.00

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/07/02

130



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

PPP

71316

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CR 11/07/08

ME

11-07-07

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 28, 2011 10:05:44 AM

Page 1

Work Order ID: 71323

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube



Start Date: 6/28/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM  
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC  
 IPP Rev:C 07-05-28 As per Rev F JLM  
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM  
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			110	Each	2,162.000	24	24			
BOLT													

Location	Loc Qty	Loc Code
ST350	2162	
117313	2	
117688	776	
117795	500	
117872	22	
118012	500	
118112	362	

AN3C6A 		Purchased	No			110	Each	264.0000	12	12			
BOLT													

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST351	263	
111982	2	
116419	23	
116549	2	
116704	12	
117514	24	
117619	50	
117688	100	
117872	50	

W/O:		WORK ORDER CHANGES					
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Tuesday, June 28, 2011 10:05:44 AM

Page 2

Work Order ID: 71323

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 6/28/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C7A

Purchased

No

110

Each

135.0000

8

8



HL 11/07/06

BOLT

## Location

## Loc Qty

## Loc Code

ST351

123

113149

14

116169

1

117313

58

117688

50

X8

ST352

12

117619

12

AN960C10L

NAS1149C0332

Purchased

No

110

Each

0.0000

44

44



1117460



(X44) HL 11/07/06

washer

D3391-021

Manufactured

No

110

Each

0.0000

1

1



B71313 (X1) HL 11/07/06

Fwd Tube Assembly

D3391-023

Manufactured

No

110

Each

0.0000

1

1



B71319 (X1) HL 11/07/06

Mid Tube Assembly

D3391-025

Manufactured

No

110

Each

0.0000

1

1



B71326 (X1) HL 11/07/06

Aft Tube Assembly

D3564-1

Manufactured

No

110

Each

2.0000

1

1



HL 11/07/06

Wearshoe

## Location

## Loc Qty

## Loc Code

FG

2

33798

2

B69291

X1

Tuesday, June 28, 2011 10:05:44 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, June 28, 2011 10:05:44 AM

Page 3

Work Order ID: 71323

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 6/28/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-3

Manufactured No

110

Each

12.0000

1

1



Wearshoe



yl 11/07/07

Location

Loc Qty

Loc Code

FG

2

33764

2

B71549

yl

FP019

10

64748

3

66000

4

69290

3

D3564-5

Manufactured No

110

Each

26.0000

1

1



Wearshoe



yl 11/07/06

Location

Loc Qty

Loc Code

FG

2

34806

2

FP019

24

68960

2

70864

22

D3566-1

Manufactured No

110

Each

12.0000

2

2



Gasket



yl 11/02/06

Location

Loc Qty

Loc Code

FP015

12

68924

2

69279

10

yz

Tuesday, June 28, 2011 10:05:44 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Tuesday, June 28, 2011 10:05:44 AM

Page 4

Work Order ID: 71323



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 6/28/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured No

110

Each

18.0000

1

1



21 1105106

Gasket

Location

Loc Qty

Loc Code

FP015

18

68961

18

21

Tuesday, June 28, 2011 10:05:44 AM

Shop Packet Print

Page 4

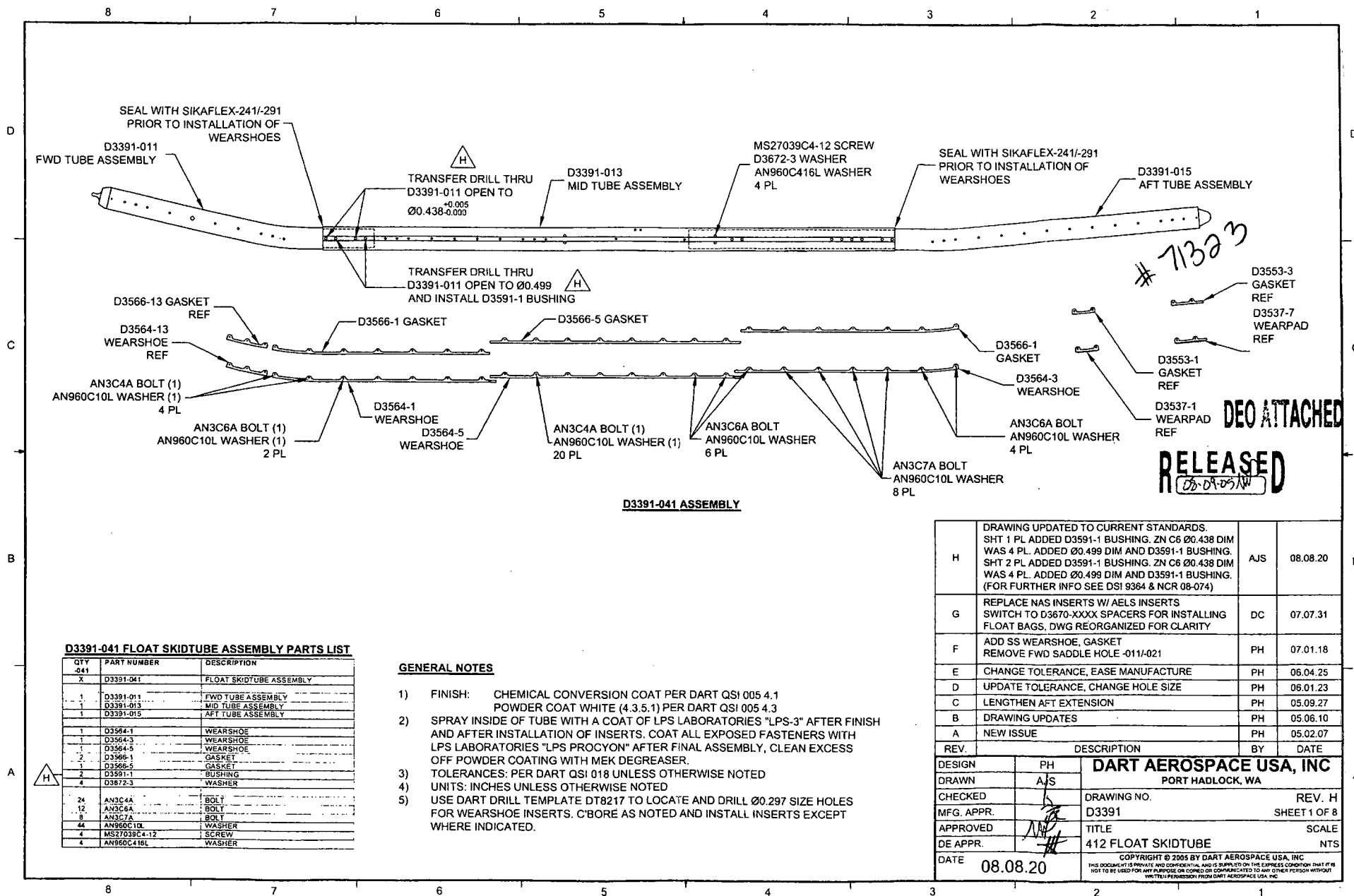
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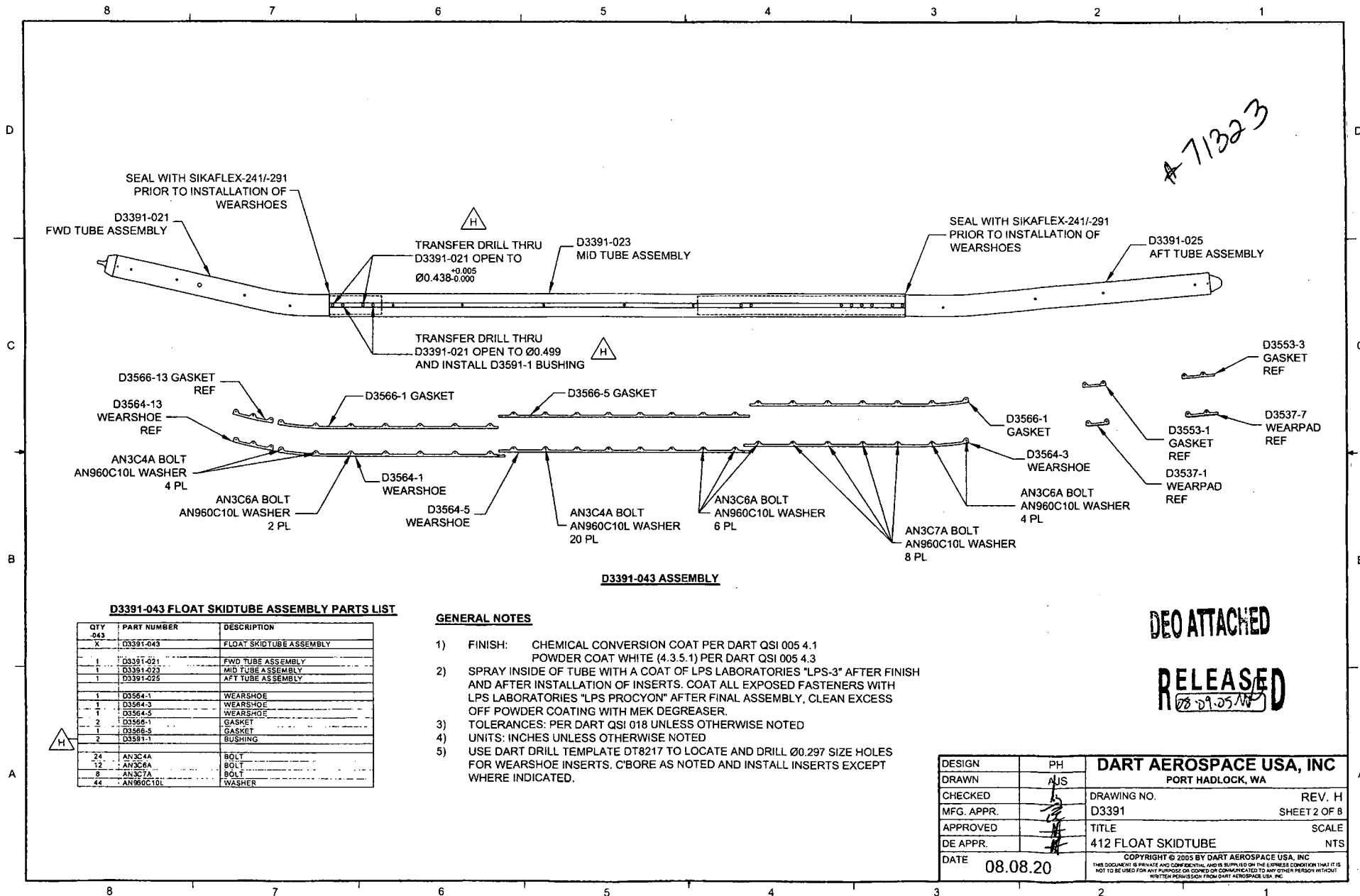
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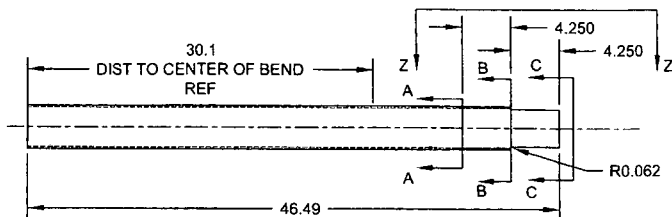
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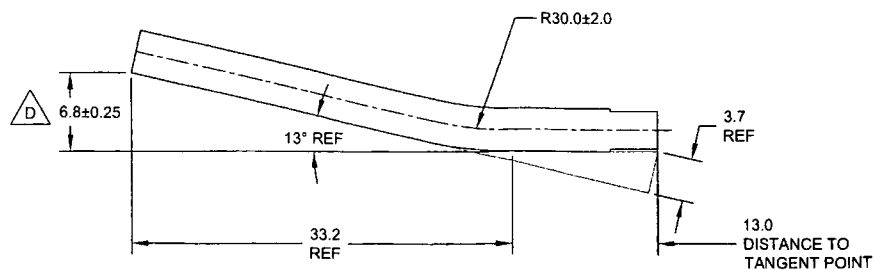
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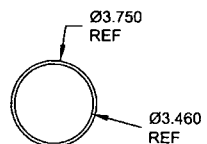
**NOTE:** Date & initial all entries



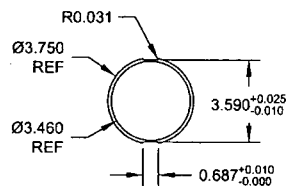
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



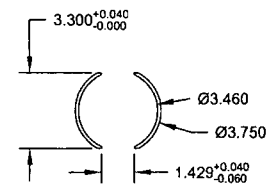
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



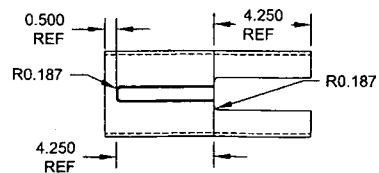
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



**VIEW Z-Z**  
SCALE 2X

DEO ATTACHED  
RELEASED  
08.05.11

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H SHEET 3 OF 8
MFG. APPR.		TITLE	SCALE
APPROVED		412 FLOAT SKIDTUBE	NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
DATE	08.08.20	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

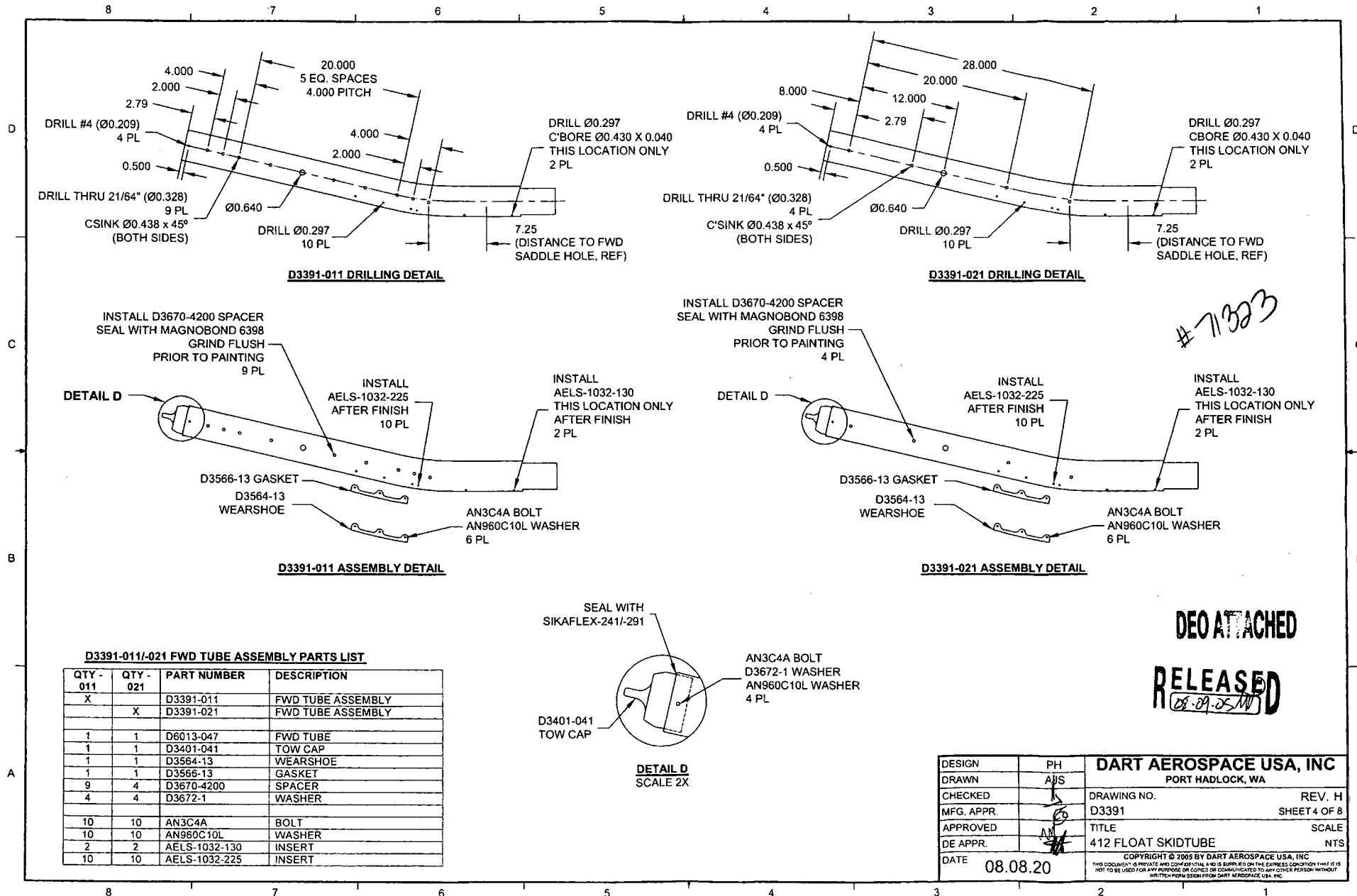
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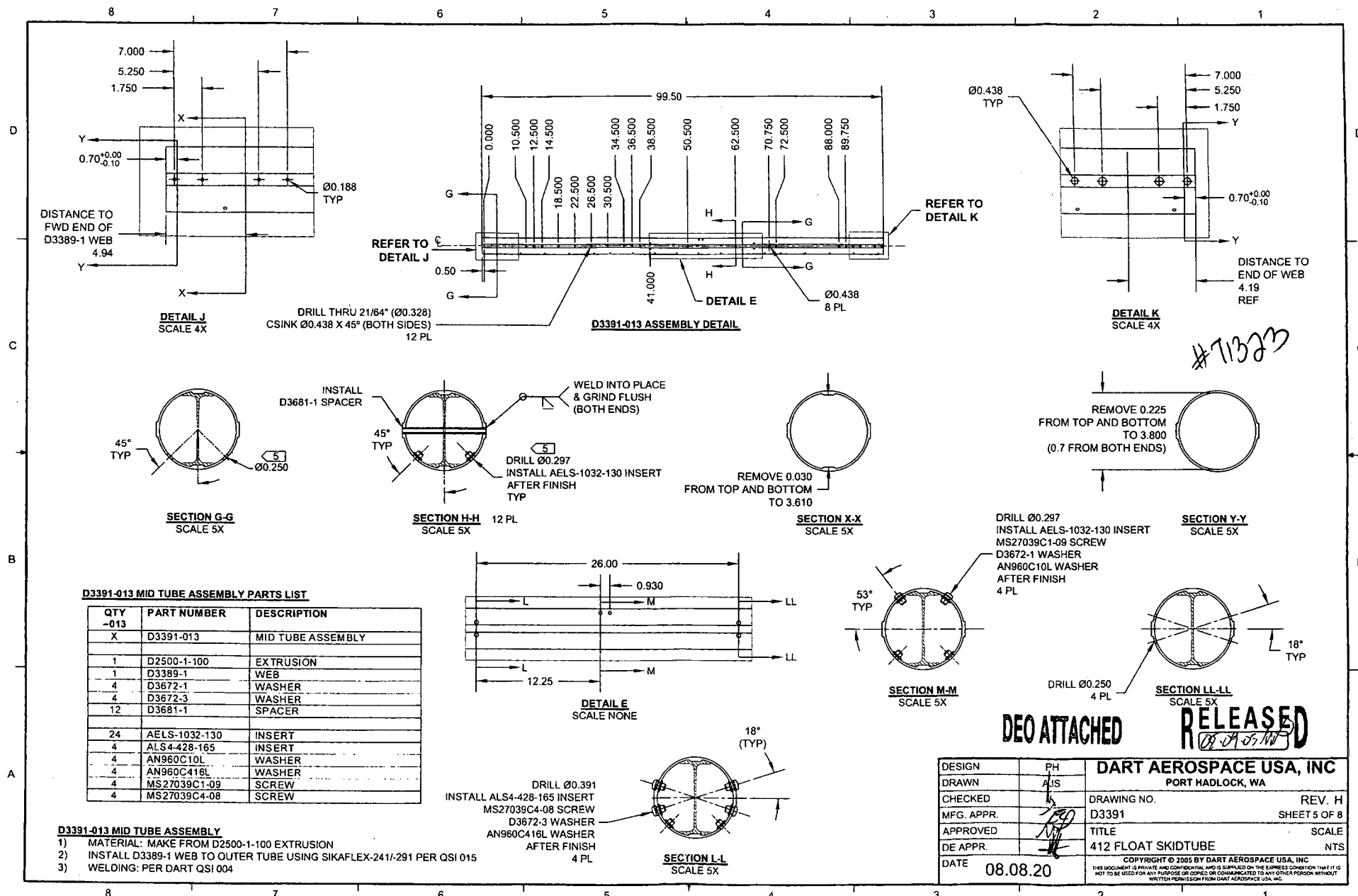
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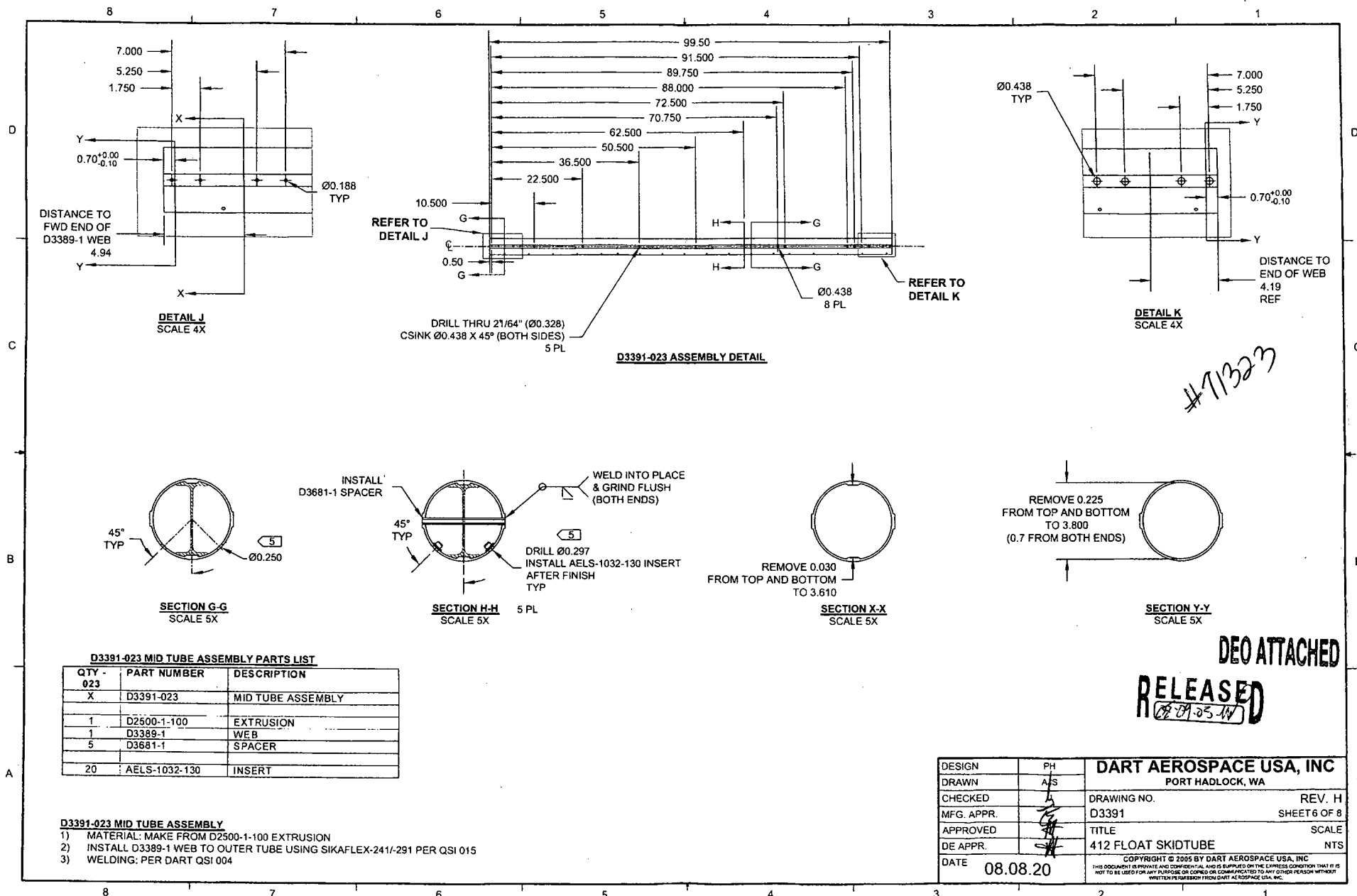
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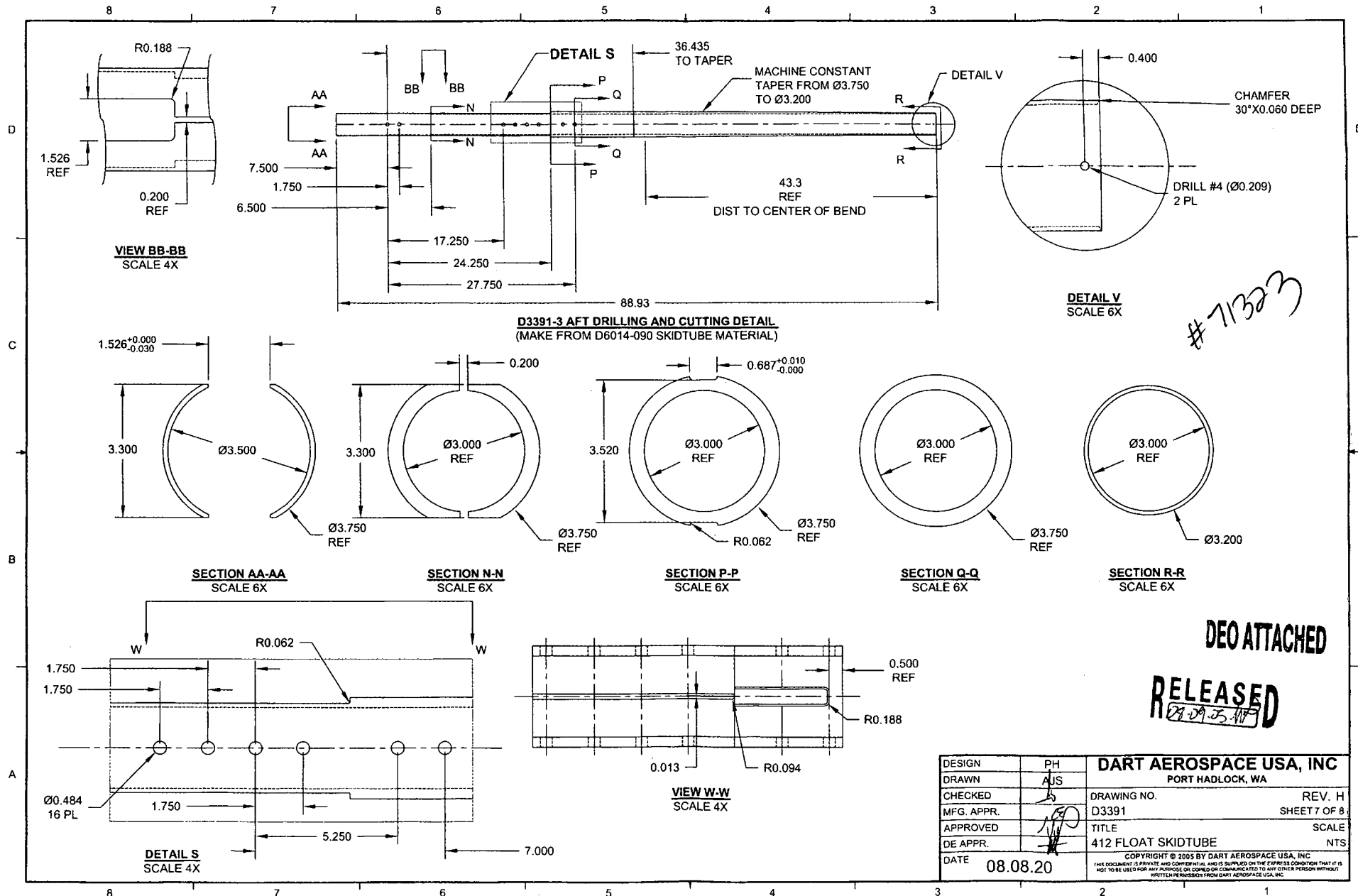
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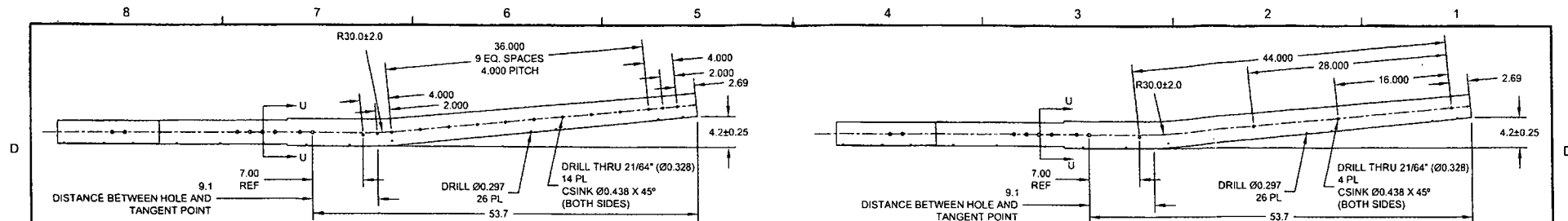
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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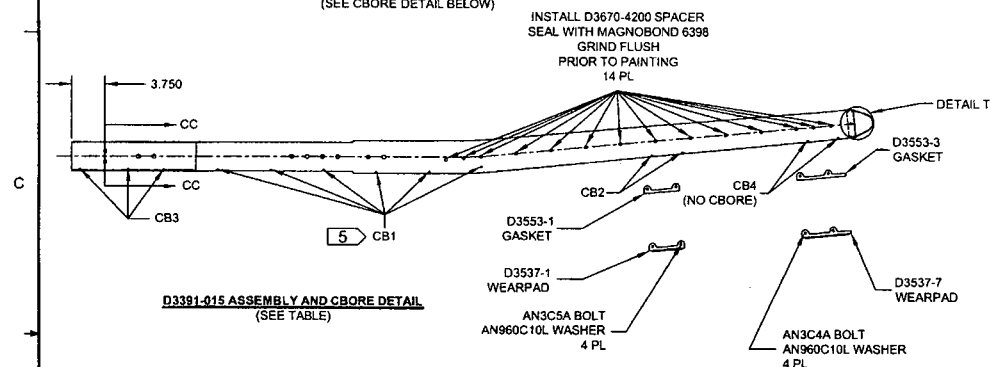
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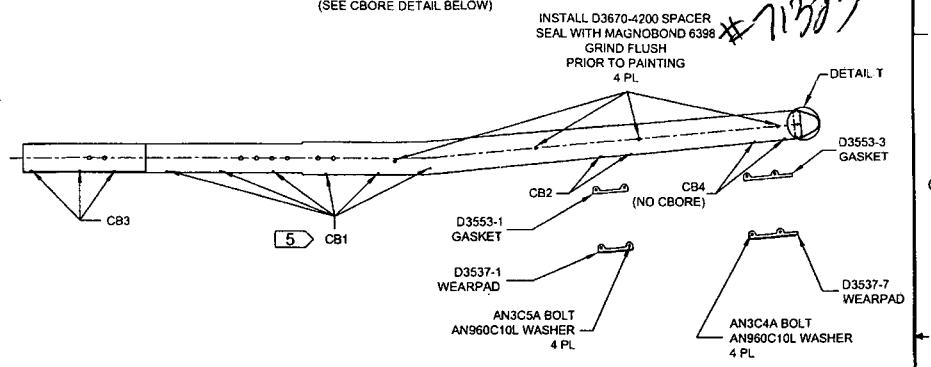


**D3391-015 BENDING AND DRILLING DETAIL**  
(SEE CBORE DETAIL BELOW)

**D3391-025 BENDING AND DRILLING DETAIL**  
(SEE CBORE DETAIL BELOW)



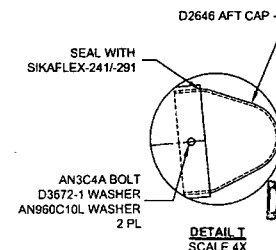
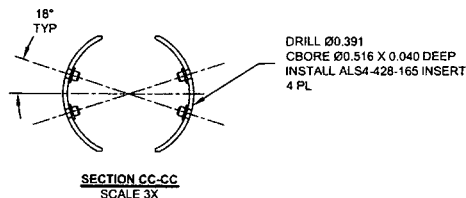
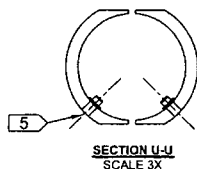
**D3391-015 ASSEMBLY AND CBORE DETAIL**  
(SEE TABLE)



**D3391-025 ASSEMBLY AND CBORE DETAIL**  
(SEE TABLE)

**D3391-015/025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND  
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	h	DRAWING NO.	REV. H
MFG. APPR.	h	D3391	SHEET 8 OF 8
APPROVED	h	TITLE	SCALE
DE APPR.	h	412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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DEO ATTACHED  
**RELEASED**  
08.09.05.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>MA</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

**PURPOSE:**

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

**CHANGE:**

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~  
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~  
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
 OFF POWDER COATING WITH MEK DEGREASER.

**RELEASED**  
 2010-02-02

*MP*

*#71323*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries